

Work Order ID: 109903

109903

Page 1

Thursday, December 05, 2013 1:10:16 PM

Item ID: D350-602-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Date: 12/5/2013 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/15/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: 

Date: 12/10/13 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9515	B

100		0.00	DAS 06 9-89	FEB 11 2015	DAS 06 9-89				
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP	D350-602-011	CHG006						

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

 DAS
27
9-89
FEB 10 2015



120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

FEB 11 2015

DAS
06
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 109903***109903***

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Thursday, December 05, 2013 1:10:16 PM

Item ID: D350-602-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Utility-Pod™ (Fits LH or RH)
Start Date: 12/5/2013 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/15/2014 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging							DAS	
Packaging	Memo	0.00						06	
Packaging	Identify and pack for shipping as per PPPD350-602-011							0-89	
	Location: <u>095</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 11 2015

ML5 1502-12

15-2-12

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 109903

Parent Item: D350-602-011

Parent Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Date: 12/5/2013

Required Date: 1/15/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F Removed Travellers 06-04-06 JLM
IPP Rev:G Added D3495-1 06-05-17 JLM
10-04-27 JLM VERIFIED BY:DD

IPP REV:H AS PER ECN10-558

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2324 Strut Assy	DAS 06 9-89	Manufactured	No			110	Each	16.0000	1	1		FEB / 0 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		16						27 9-89	
				100928		7							
				105350		7							
				98393		2							
D2694 Pod, 350/407	DAS 06 9-89	Manufactured	No			110	Each	0.0000	1	1		FEB / 0 2015	
D4091-1 Mounting Lug	DAS 06 9-89	Manufactured	No			110	Each	15.0000	4	4		FEB / 0 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST144		15						27 9-89	
				107990		15							
D3910-3 X-Tube Lug	DAS 06 9-89	Manufactured	No			110	Each	8.0000	4	4		FEB / 0 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST464		8						27 9-89	
				105941		2							
				106273		6							
D2258-160 Placard	DAS 06 9-89	Manufactured	No			110	Each	8.0000	1	1		FEB / 0 2015	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Return2012		2						27 9-89	
				62072		2							
				ST007		6							
				62072		2							
				84437		4							

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
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Material									
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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 109903

Parent Item: D350-602-011

Parent Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Date: 12/5/2013

Required Date: 1/15/2014

Start Qty: 1.00

Required Qty: 1.00

D2523
Mounting Bracket

DAS
CS
9-59

Manufactured No

110 Each 8.0000 2 2

DAS
27
9-59

DAS
CS
9-59

Location

Loc Qty

Loc Code

ST166

8

102475

2

105348

5

84863

1

B113708

FEB / 0 2013

D2524
Bracket Clamping

DAS
CS
9-59

Manufactured No

110 Each 8.0000 2 2

DAS
27
9-59

DAS
CS
9-59

Location

Loc Qty

Loc Code

ST479

8

102234

4

107684

4

B2390

FEB / 0 2015

D3495-1
Placard

DAS
CS
9-59

Manufactured No

110 Each 5.0000 1 1

DAS
27
9-59

DAS
CS
9-59

Location

Loc Qty

Loc Code

Return2012

3

65128

3

ST051

2

55564

1

65128

1

FEB / 0 2015

D3984
Rubber Extrusion, X-Tube, Per Foot
CUT 8 AT 3.00"

DAS
CS
9-59

Manufactured No

110 f 114.0010 2 2

DAS
27
9-59

DAS
CS
9-59

Location

Loc Qty

Loc Code

ST408

14

103101

14

ST411

100.001

107420

100

53707

0.001

B12892S

FEB / 0 2015

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 109903

Parent Item: D350-602-011

Start Date: 12/5/2013

Required Date: 1/15/2014

Parent Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

AN3-7A Bolt Purchased No

110 Each 242.0000

4 4

DAS 27 9-89

DAS 66 9-89

Location Loc Qty Loc Code

ST351 142
124221 2
124805 10
M127070 130
ST511 100
M126175 100

M129706

4

FEB 10 2015

AN3-15A Bolt Purchased No

110 Each 45.0000

8 8

DAS 27 9-89

DAS 66 9-89

Location Loc Qty Loc Code

FG 7
114941 7
ST351 38
114941 3
116419 6
M125952 4
M126400 25

M123429

8

FEB 10 2015

AN4-12A Bolt Purchased No

110 Each 145.0000

1 1

DAS 27 9-89

DAS 66 9-89

Location Loc Qty Loc Code

FG 10
120423 10
ST356 135
111605 2
120423 4
M126105 129

M120884

1

FEB 10 2015

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 109903

Parent Item: D350-602-011

Start Date: 12/5/2013

Required Date: 1/15/2014

Parent Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

AN4-14A Bolt Purchased No

110 Each 295.0000 16 16

DAS
27
8-59

DAS
27
8-59

FEB / 0 2015

Location Loc Qty Loc Code

FG 5
122141 5
ST357 34
115374 1
121349 16
123352 5
M117873 12
ST514 1
M126105 1
ST515 235
M127044 235
ST517 20
124221 20

m131153 16

u

AN4-16A Bolt Purchased No

110 Each 213.0000 4 4

DAS
27
8-59

DAS
27
8-59

FEB / 0 2015

Location Loc Qty Loc Code

FG 5
121541 5
ST361 208
124215 8
125427 53
M126073 47
M127432 100

m131139 4

u

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, December 05, 2013 1:10:15 PM

Page 5

Work Order ID: 109903

Parent Item: D350-602-011

Parent Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Date: 12/5/2013

Required Date: 1/15/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

110

Each

4,246.0000

24

24

Washer

DAS
06
9-59

Location

Loc Qty

Loc Code

FP001

1

123248

1

ST294

108

113068

11

124392

97

ST510a

4137

m126319

4137

FEB 10 2015

DAS
06
9-59

NAS1149D0463J

Purchased

No

110

Each

5,475.0000

42

42

WASHER

DAS
06
9-59

Location

Loc Qty

Loc Code

FP001

2

122441

2

ST294

408

119097

1

121912

24

124198

35

124778

83

M127255

265

ST510a

5065

M126221

65

M127693

5000

m120799

FEB 10 2015

DAS
06
9-59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 6

Thursday, December 05, 2013 1:10:15 PM

Work Order ID: 109903

Parent Item: D350-602-011

Parent Item Name: Heli-Utility-Pod™ (Fits LH or RH)

Start Date: 12/5/2013

Required Date: 1/15/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Nut

Purchased

No

110

Each

6,423.0000

12

12

DAS

27

FEB 10 2015

DAS
66
9-69

Location

Loc Qty

Loc Code

ST314

1035

M126036

35

M127304

1000

ST506

814

123900

814

ST509

3000

M127410

3000

ST510a

1574

M126275

8

M126333

1566

m131264

12

4

DAS

27

FEB 10 2015

MS21042L4

Locknut

Purchased

No

110

Each

4,489.0000

21

21

DAS

27

FEB 10 2015

DAS
66
9-69

Location

Loc Qty

Loc Code

FP001

84

122452

38

8182

12

m117441

12

m119017

6

m121444

16

ST314

9

m125708

9

st507

33

m126073

33

ST509

4078

m123376

2000

m126275

184

m127255

1894

ST510a

127

m126333

127

ST518

158

124231

158

m130799

4

Thursday, December 05, 2013 1:10:16 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-602 REV E (OR EARLIER REV.)
AND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D350-602 REV. 0

REF. TCCA STC: SH93-97

REF. FAA STC: SR01144NY

REF. EASA STC: EASA.IM.R.S.01290

PURPOSE

Dart Heli-Utility-Pods D350-602-011 @ CHG 006 and D350-602-013/-014 @ CHG 002 have new attachment lugs.

CHANGE

The D2230-1/-3 clamps are replaced with wider D4091-1/D3910-3 lugs. The abrasion strip is replaced with D3984-030 rubber extrusion. The D2462-1700 Neoprene Seal is replaced with D2461-1700 Neoprene 'D' Seal. The modified parts list for Installation Instruction D350-602 and Instructions for Continued Airworthiness ICA-D350-602 is shown on sheet 2 of this service instruction. Install the lugs as shown in Figure 1 & 2 of this service instruction. The pod should otherwise be installed per D350-602 and maintained per ICA-D350-602.

The weight and balance for Dart Heli-Utility-Pods D350-602-011 @ CHG 006 and D350-602-013/-014 @ CHG 002 (or later) are updated as follows:

5.0 WEIGHT AND BALANCE (D350-602 Rev. E)

25.6 WEIGHT AND BALANCE (ICA-D350-602 Rev. 0)

The following weight and balance information is for the Dart **Heli-Utility-Pod™**. The weight and balance of any parts that are removed from the aircraft to perform this installation or equipment installed/stowed in the pods are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-602-011 @ CHG 006 Heli-Utility-Pod™ LH or RH	61.2 lb 27.8 kg	±51.0 in ±1.29 m	±3121 in-lb ±35.9 m-kG	135 in 3.43 m	8262 in-lb 95.4 m-kG
D350-602-013 @ CHG 002 Heli-Utility-Pod™ LH	61.2 lb 27.8 kg	-51.0 in -1.29 m	-3121 in-lb -35.9 m-kG	135 in 3.43 m	6872 in-lb 79.2 m-kG
D350-602-014 @ CHG 002 Heli-Utility-Pod™ RH	61.2 lb 27.8 kg	+51.0 in +1.29 m	+3121 in-lb +35.9 m-kG	135 in 3.43 m	6872 in-lb 79.2 m-kG

LUG UPGRADE KIT

The Dart DSI-9515-011 kit is available to upgrade D350-602-XXX Heli-Utility-Pods made to earlier change numbers with D4091-1 / D3910-3 lugs. The lugs should be installed per Figure 1 & 2 of this service instruction.

QTY	Part Number	Description
-011		
X	DSI-9515-011	LUG UPGRADE KIT
4	D4091-1	LUG
4	D3910-3	LUG
8	D3984-030	RUBBER EXTRUSION
16	AN4-14A	BOLT
32	AN960JD416	WASHER (OR NAS1149DO463J)
16	MS21042L4	NUT (OR MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.23

CERT. NO.: SH93-97

ISSUE NO.: 4

B	NAS1149DO463J WAS xDN432J & CHG QTY	CP	10.04.23
A	NEW ISSUE	CP	10.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9515	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG MODIFICATION	NTS
DATE	10.04.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

6.0 PARTS LIST

Qty D350-602 -011	Qty D350-602 -013	Qty D350-602 -014	Qty DSI9052 -013	Part Number	Description
LX				D350-602-011	HELI-UTILITY-POD™ (FITS BOTH LH/ RH)
	X			D350-602-013	HELI-UTILITY-POD™, LH
		X		D350-602-014	HELI-UTILITY-POD™, RH
			X	DSI9052-013	QUICK RELEASE KIT
1.1				D2694	POD ASSEMBLY (LH OR RH)
	1			D3322-041	POD ASSEMBLY (LH)
		1		D3322-042	POD ASSEMBLY (RH)
1	1	1		*D2202-1	POD LID
1				*D2202-3	POD BASE
	1	1		*D2202-5	POD BASE
5	5	5		*D2204-9	LATCH
1	1	1		*D2429-041	SPRING CLIP ASSEMBLY
1	1	1		*D2462-1700	NEOPRENE SEAL
5	5	5		*D2528-1	BACKER PLATE
4	4	4		*D2528-3	BACKER PLATE
1	1	1		*D2569	HINGE
1	1	1		*D3007-041	PROP ASSEMBLY
1	1	1		** D2012-107	CLEVIS
2	2	2		** D2022-101	SPACER
1	1	1		** D2705	SUPPORT BRACKET
1	1	1		** D3007-1	STRUT
1	1	1		** D3015-3	LOCKNUT
1	1	1		** AN4-10A	BOLT
1	1	1		** AN960JD416	WASHER
1	1	1		** MS21042L4	NUT (OR MS21042-4)
1	1	1		** SL69-BS	BALL STUD
1	1	1		** AN960JD516	WASHER
19	19	19		AN4-5A	BOLT
1	1	1		AN4-6A	BOLT
2	2	2		AN526C632R7	SCREW
21	21	21		AN960JD416	WASHER
2	2	2		AN960JD6	WASHER
2	2	2		MS21042L06	NUT (OR MS21042-06)
20	20	20		MS21042L4	NUT (OR MS21042-4)
4	4	4		D2230-1	CLAMP
4	4	4		D2230-3	CLAMP
(1)	1	1		D2258-160	LABEL
1.1	1	1		D2324-1	STRUT ASSEMBLY
1.2	2	2		D2523	MOUNTING BRACKET
1.2	2	2		D2524	SIDE PLATE
4	4	4		D2856-400-720	ABRASION STRIP
1	1	1		D3495-1	PLACARD
4	4	4		AN3-7A	BOLT
8	8	8		AN3-15A	BOLT
1	1	1		AN4-12A	BOLT
8	8	8		AN4-13A	BOLT
4	4	4		AN4-16A	BOLT
24	24	24		AN960JD10	WASHER
26	26	26		AN960JD416	WASHER
12	12	12		MS21042L3	NUT (OR MS21042-3)
13	13	13		MS21042L4	NUT (OR MS21042-4)
			1	BLRS-010	QUICK RELEASE PIN (1" GRIP)
			3	BLRS-020	QUICK RELEASE PIN (1.5" GRIP)

* INCLUDED IN D2694 OR D3322-041/-042 POD ASSEMBLIES LISTED ABOVE

** INCLUDED IN D3007-041 PROP ASSEMBLY LISTED ABOVE

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Revision: E

Date: 06.01.23

32
26
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